

We claim:

1. A siding panel, comprising:
a sheet of polymeric material, said sheet including a molded central portion comprising a plurality of adjacent shingle impressions of substantially the same length, each of said shingle impressions including a bottom edge, at least one of said bottom edges being beveled to give the appearance of shingles having different lengths.

2. The siding panel of claim 1, further comprising:
a first lateral edge portion containing a butt edge; and
a second lateral edge portion containing a nail edge and including a plurality of fastener apertures therethrough, said first and second lateral edge portions being formed substantially independently from said forming of said central portion while the polymeric material in said central portion has a temperature below its heat deflection temperature and the polymeric material in said first and second lateral edge portions is above its heat deflection temperature.

3. The siding panel of claim 1, wherein said shingle impressions are vacuum formed on a rotating belt.

4. The siding panel of claim 1, wherein said polymeric material comprises polyvinyl chloride.

5. The siding panel of claim 1, wherein said siding panel has a length of at least 10'.

6. The siding panel of claim 1, wherein said central portion comprises a thickness of about .03-.125".

1 7. The siding panel of claim 1, wherein said shingle impressions are cedar shake shingle
2 impressions and a plurality of said bottom edges are beveled.

1 8. The siding panel of claim 7, wherein alternating bottom edges are beveled.

1 9. The siding panel of claim 7, wherein said plurality of said bottom edges are beveled in a
2 non-periodic pattern.

1 10. A continuously formed siding panel, comprising:
2 a sheet of polymeric material, including a central portion comprising a plurality of
3 adjacent shingle impressions of substantially the same length, each of said shingle impressions
4 including a bottom edge, a plurality of said bottom edges being beveled to give the appearance of
5 shingles having different lengths;
6 a butt edge disposed along a first lateral edge portion of said sheet; and
7 a nail edge disposed along a second lateral edge portion of said sheet, said butt edge and
8 said nail edge being formed substantially independently from said central portion.

1 11. The siding panel of claim 10, wherein said shingle impressions are vacuum formed, blow
2 molded, compression molded, transfer molded or injection molded.

1 12. The siding panel of claim 10, wherein said shingle impressions are cedar shake shingle
2 impressions.

1 13. The siding panel of claim 12, wherein alternating bottom edges are beveled.

1 14. The siding panel of claim 12, wherein said bottom edges are beveled in a non-periodic
2 pattern.

- 1 15. A continuously formed siding panel of substantially unlimited length, comprising:
2 an extruded sheet of polymeric material comprising polyvinyl chloride, said sheet
3 including a central vacuum-formed portion having a plurality of adjacent cedar shake shingle
4 impressions of substantially the same length, each of said cedar shake shingle impressions having
5 a bottom edge, a plurality of non-adjacent cedar shake shingles having a bottom which is beveled
6 to give the appearance of shingles having different lengths;
7 a butt edge disposed along a first lateral edge portion of said sheet; and
8 a nail edge disposed along a second lateral edge portion of said sheet, said lateral edge
9 portions formed after said central portion has been vacuum-formed and while the polymeric
10 material in said lateral edge portions is above the heat deflection point of said polymeric
11 material.
12
13 16. A method of manufacturing a shaped polymeric article, comprising the steps of:
14 providing a sheet of extruded hot polymeric material;
15 disposing said sheet onto a rotating belt, said rotating belt including a mold impression
16 therein and a plurality of apertures therethrough, said mold impression resembling a plurality of
17 adjacent shingle impressions of substantially the same length, each of said shingle impressions
18 including a bottom edge, at least one of said bottom edges being beveled to give the appearance
19 of shingles having different lengths;
20 applying vacuum pressure to said hot polymeric material through said belt, so as to draw
21 said sheet into intimate forming contact with said mold impression to form a patterned central
22 portion;
23 cooling said patterned sheet portion below a heat deflection temperature of said polymeric
24 material; and
25 severing a length of said shaped sheet to produce a shaped polymeric article.

D0932-00230

20. The method of claim 16, wherein said vacuum pressure is applied to form a patterned central portion and a pair of lateral edge portion, said method further comprising the steps of:
further forming said lateral edge portions; and
cooling said lateral edge portions below said heat deflection temperature to produce a relatively continuous shaped sheet.

45 FEB 1964